

Friday, 11/18/2005 3:03:36 PM
Linda Lacello

Process Sheet

SPLIT

| | | | | | | |
|-----------------------|---|--|------------------|---------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : WEARPAD | | |
| Job Number | : 24843 - 1 | | Part Number | : D26483 | | |
| Estimate Number | : 10313 | | Drawing Number | : D2648 REV D | | |
| P.O. Number | : N/A | | Project Number | : N/A | | |
| This Issue | : 11/18/2005 S.O. No. : N/A | | Drawing Revision | : D | | |
| Prsht Rev. | : NC | | Material | : N/A | | |
| First Issue | : N/A | | Due Date | : 12/20/2005 | | |
| Previous Run | : 23978 | | Qty: | 400 Um: Each | | |
| Written By | : SEE COMMENT BELOW | | | | | |
| Checked & Approved By | : SEE ABOVE DATE & SIGN | | | | | |
| Comment | : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|------|
| 1.0 | PG | PURCHASING | |
| | | Comment: PURCHASING Issue P/O: 146 Email or ship DXF file to vendor Make per Drawing D2648-1 Material release note required | |
| 2.0 | D26483F | Wearpad | |
| | | Comment: Qty.: 1.0000 Each(s)/Unit Total: 400.0000 Each(s) WEARPAD | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| | | Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material release note is attached | |
| 4.0 | QC6 | DIMENSIONAL CHECK | |
| | | Comment: DIMENSIONAL CHECK | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng./ Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/07/22
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 24843

Part Number: D26483

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 06/01/10

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat

M19442

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

CPL 06-01-31

(200)

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/01/31 (200)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 06/01/31 (200)

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 02 21 200

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06 02 21 200

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

M 06 02 21 200

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/22 (200)



06/02/22

W/O:

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

| | | | | |
|-------------------|---|----------|------------------------------|----------------|
| Work Order No | : | 0024843 | Department Code: | |
| Project Name | : | D2648-3 | Burden Flags | : NNNNNNN |
| Project For | : | WK550 | WO Status | : Open |
| Work Order Type | : | Main | Invoice State | : Not Invoiced |
| Main WO Number | : | | Invoice Date | : |
| House Part Number | : | D2648-3 | Invoice Number | : |
| Description | : | Wearpad | Invoice Amount | : 0.00 |
| Manufactured | : | Yes | | |
| Amount Req'd | : | 400 | Order Entry No | : |
| Amount Done | : | 0 | OE Value | : 0.00 |
| Start Date | : | 11-17-05 | Est Margin | : 0.000% |
| Est Finish Date | : | 12-20-05 | Actual Margin | : 0.000% |
| Act Finish Date | : | | | |
| Drawings Reqd | : | No | | |
| Ok for Approval | : | | | |
| Approval Rec'd | : | | \$0 Posted to Finished Goods | |

| | Estimated | Actual | Var. % | Posted | To Post |
|-------------------|-----------|--------|--------|--------|---------|
| Material Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Cost | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. | : 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden | : 0.00 | 0.00 | 0.00 | | |
| Total Cost | : 0.00 | 0.00 | 0.00 | | |
| Margin | : 0.000 | 0.000 | | | |
| Selling Cost | : 0.00 | 0.00 | | | |

| | Estimated | Actual |
|------------------------|-----------|--------|
| Labour Hrs/Amount Bono | : 0.00 | 0.00 |
| Profits/(Loss) | : 0.00 | 0.00 |



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8069 / 235 3535 Waikato
Fax: (09) 375 8950

TEST CERTIFICATE

Ref: S210/22495

| CUSTOMER | Wilkinson | P50323 DI001 | SPECIFICATION | ASTMA1008 CS Type A | | | | | | | | | | CERTIFICATE No | TC112397 | | | | | | | | | |
|-------------------------------------|------------|--------------|---------------|---------------------|----|----|-------|----|----|----|---|--------|----|----------------|--------------|-------|-------|------|-------|------|--------|----------|------|---------------|
| CUSTOMER D/N | 98-21N-686 | | PRODUCT | CRA WIDE COIL | | | | | | | | | | PAGE | 1 of 1 | | | | | | | | | |
| MILL O/N | 480737 | | DIMENSIONS | 0.055" x 48" x Coil | | | | | | | | | | DATE | 09 June 2005 | | | | | | | | | |
| CHEMICAL COMPOSITION PERCENT | | | | | | | | | | | | | | | | | | | | | | | | |
| PACK NUMBER | HEAT No | C | Si | Mn | P | S | Cu | Ni | Cr | Mo | V | Nb | Ti | Al | B | N2 | CE(%) | BEND | YIELD | T.S. | %ELONG | HARDNESS | r | LENGTH (feet) |
| | | x100 | | | | | x1000 | | | | | x10000 | | x100 | 180° | G.L.= | HRB | () | | | | | | |
| R9-459713-00 | 641758 | 4 | TR | 18 | 4 | 16 | 13 | 19 | 10 | 5 | 3 | 1 | 1 | | | | Good | | | | 54 | | 1585 | |
| R9-459714-00 | 641758 | 4 | TR | 18 | 4 | 16 | 13 | 19 | 10 | 5 | 3 | 1 | 1 | | | | Good | | | | 54 | | 1457 | |
| R9-459715-00 | 641513 | 5 | TR | 18 | 9 | 18 | 12 | 17 | 15 | 1 | 6 | 1 | 1 | | | | Good | | | | 48 | | 1375 | |
| R9-459716-00 | 641513 | 5 | TR | 18 | 9 | 18 | 12 | 17 | 15 | 1 | 6 | 1 | 1 | | | | Good | | | | 48 | | 1473 | |
| R9-459717-00 | 641756 | 5 | TR | 20 | 12 | 19 | 12 | 18 | 19 | 1 | 7 | 1 | 1 | | | | Good | | | | 48 | | 1631 | |
| R9-459718-00 | 641756 | 5 | TR | 20 | 12 | 19 | 12 | 18 | 19 | 1 | 7 | 1 | 1 | | | | Good | | | | 48 | | 1093 | |
| R9-459719-00 | 641756 | 5 | TR | 20 | 12 | 19 | 12 | 18 | 19 | 1 | 7 | 1 | 1 | | | | Good | | | | 50 | | 1562 | |
| R9-459720-00 | 641756 | 5 | TR | 20 | 12 | 19 | 12 | 18 | 19 | 1 | 7 | 1 | 1 | | | | Good | | | | 50 | | 1535 | |
| R9-460380-00 | 641761 | 4 | TR | 20 | 13 | 17 | 12 | 18 | 25 | 5 | 8 | 1 | 1 | | | | Good | | | | 50 | | 1581 | |
| R9-460387-00 | 641758 | 4 | TR | 18 | 4 | 16 | 13 | 19 | 10 | 5 | 3 | 1 | 1 | | | | Good | | | | 49 | | 1562 | |
| R9-460382-00 | 641758 | 4 | TR | 18 | 4 | 16 | 13 | 19 | 10 | 5 | 3 | 1 | 1 | | | | Good | | | | 48 | | 1503 | |
| R9-461458-00 | 642309 | 2 | TR | 18 | 10 | 20 | 11 | 17 | 19 | 1 | 6 | 1 | 1 | | | | Good | | | | 48 | | 1785 | |

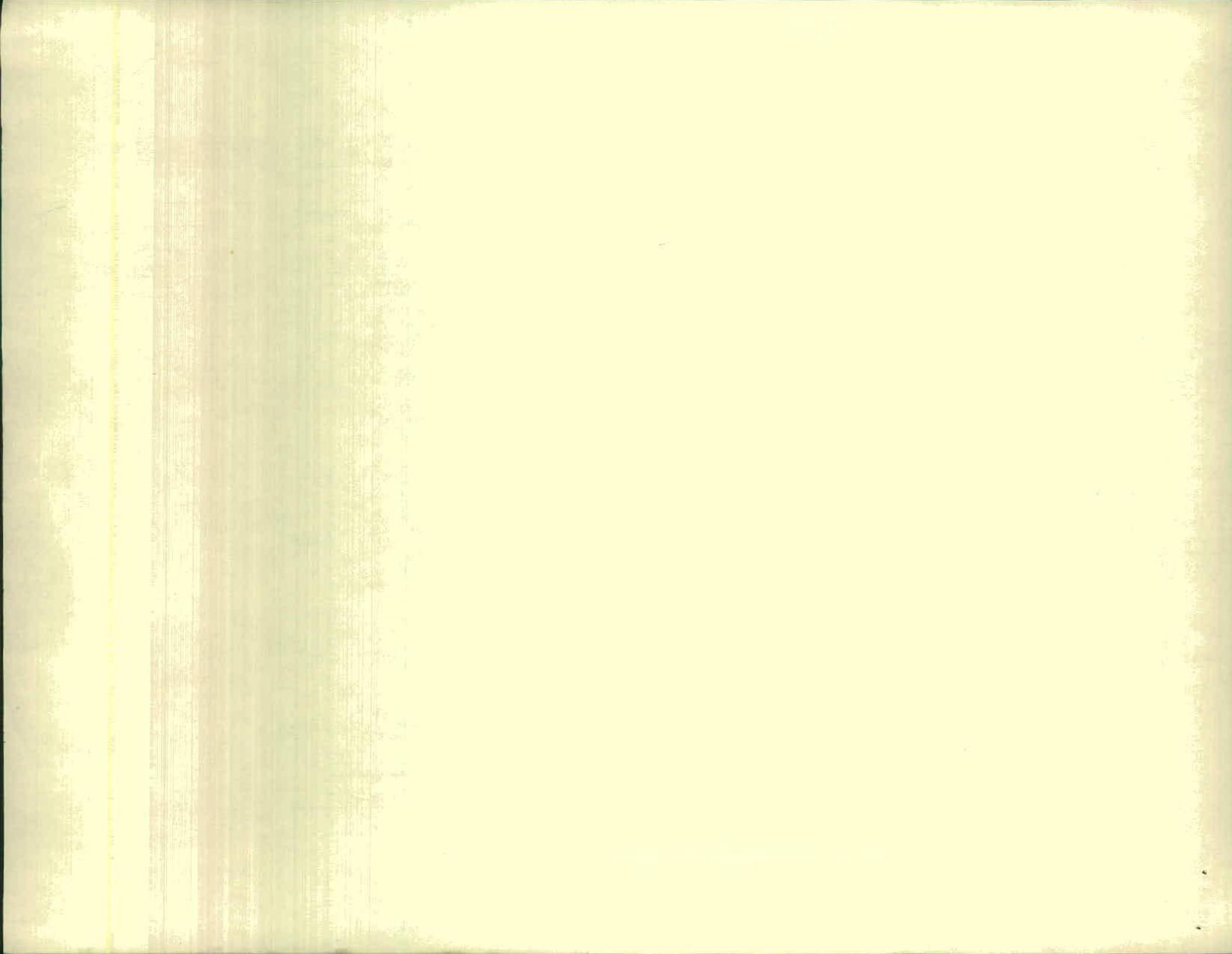
| | | | | | |
|--|--|---|--|---|---|
| YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS | GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm | PLASTIC STRAIN RATIO (r) (A)=0 (B)=90 | IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm | (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm | CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)= |
|--|--|---|--|---|---|

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
OC METALLURGIST

P-07 146, 245, 267

16 gm/m



 永茂實業股份有限公司
YIH MAU CORP.

INVOICE NO. :
COMMODITY :

SUPPLIER/SHIPPER :
CUSTOMER :

INSPECTION CERTIFICATE MATERIAL TEST/INSPECTION CERTIFICATES

FORM#71
PRIME COLD-ROLLED STAINLESS STEEL SHEET AISI 304L/304 (SIC)
FINISH, WITH 100 MICR. FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE AND 304L/304 FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE.

ASTM 304

INTEGRIS METALS LTD

地址:高雄縣路竹鄉頭寮里345號
345, SHUH AN RD, LU CHU HSIAO
KAOSHING TAIWAN R.O.C.
TEL:07/5972808 FAX:07/5972808
CERTIFICATE NO:0408222
DATE OF ISSUE:2005/03/28

| (ITEM NO) SIZE | NO. | Weight (N.W.) | | Item No. | ID NO. | Physical Properties Tensile Test GL=50 mm | | | | | Chemical Composition (%) | | | | | | | |
|---|-----|------------------|--------|----------|--------------|---|------------------------------|-----------|-----|-----|-----------------------------|------------|------------|------------|------------|------------|------------|-----------|
| | | KGS | LBS | | | V.S. (mm) | T.S. (N/mm ²) | EL (%) | HRB | HV | C x100 | Si x100 | Mn x100 | P x1000 | S x1000 | Ni x100 | Cr x100 | N x100 |
| | | | | | | | | | | | | | | | | | | |
| AST 304 2B (428-2220) | | | | | | | | | | | | | | | | | | |
| 304GA487X120 [*] (428-5221) | 1 | 1,473 | 3,247 | YU132553 | 34321644B-4 | 285 | 639 | 58 | 61 | 150 | 3.9 | 49 | 115 | 24 | 4 | 807 | 1827 | 3.2 |
| 304GA487X120 [*] (428-5221) | 1 | 1,445 | 3,186 | YU228940 | 34321939B-5 | 280 | 660 | 57 | 60 | 158 | 4.2 | 46 | 118 | 24 | 8 | 820 | 1828 | 2.8 |
| 304GA487X120 [*] (428-5221) | 1 | 1,457 | 3,112 | YU228245 | 35522525A-3 | 285 | 635 | 54 | 62 | 159 | 4.6 | 48 | 126 | 30 | 3 | 815 | 1827 | 2.5 |
| 304GA487X120 [*] (428-5220) | 1 | 1,435 | 3,164 | YU131655 | 35522522A-2 | 312 | 684 | 54 | 63 | 183 | 4.5 | 48 | 107 | 32 | 7 | 812 | 1834 | 2.2 |
| 304GA487X120 [*] (428-5220) | 1 | 1,435 | 3,164 | YU131655 | 35522522A-3 | 312 | 684 | 54 | 63 | 183 | 4.5 | 48 | 107 | 32 | 7 | 812 | 1834 | 2.2 |
| 304GA487X120 [*] (428-5220) | 1 | 1,414 | 3,117 | YU131655 | 35522522A-4 | 312 | 684 | 54 | 63 | 183 | 4.5 | 48 | 107 | 32 | 7 | 812 | 1834 | 2.2 |
| 304GA487X120 [*] (428-5220) | 1 | 1,480 | 3,263 | YU228528 | 35523009A-4 | 277 | 656 | 54 | 77 | 145 | 4 | 47 | 112 | 28 | 4 | 821 | 1816 | 2.9 |
| 304GA487X120 [*] (428-5220) | 1 | 1,437 | 3,168 | YU228051 | 35522903C-5 | 296 | 660 | 53 | 62 | 180 | 4.2 | 49 | 114 | 32 | 5 | 810 | 1813 | 1.7 |
| 304GA487X120 [*] (428-5220) | 1 | 1,430 | 3,163 | YU132690 | 35523001B-11 | 281 | 637 | 55 | 60 | 154 | 4.4 | 50 | 113 | 30 | 5 | 801 | 1811 | 2.6 |
| 304GA487X120 [*] (428-5220) | 1 | 1,430 | 3,158 | YU132690 | 35523001B-9 | 281 | 637 | 55 | 60 | 154 | 4.4 | 50 | 113 | 30 | 5 | 801 | 1811 | 2.6 |
| 304GA487X120 [*] (428-5220) | 1 | 1,391 | 3,067 | YU132690 | 35523008B-12 | 281 | 637 | 55 | 60 | 154 | 4.4 | 50 | 113 | 30 | 6 | 801 | 1811 | 2.6 |
| 304GA487X120 [*] (428-5220) | 1 | 1,465 | 3,230 | YU228945 | 35523007A-12 | 306 | 665 | 53 | 63 | 165 | 4.9 | 45 | 108 | 24 | 5 | 817 | 1824 | 3.1 |
| 304GA487X120 [*] (428-5220) | 1 | 1,371 | 3,023 | YU228945 | 35523007A-13 | 306 | 665 | 53 | 63 | 165 | 4.9 | 45 | 108 | 24 | 5 | 817 | 1824 | 3.1 |
| 304GA487X120 [*] (428-5220) | 1 | 1,375 | 3,031 | YU228945 | 35523007A-14 | 306 | 665 | 53 | 63 | 165 | 4.9 | 45 | 108 | 24 | 5 | 817 | 1824 | 3.1 |
| 304GA487X120 [*] (428-5220) | 1 | 1,375 | 3,031 | YU228945 | 35523007A-15 | 306 | 665 | 53 | 63 | 165 | 4.9 | 45 | 108 | 24 | 5 | 817 | 1824 | 3.1 |
| 304GA487X120 [*] (428-5220) | 1 | 1,423 | 3,157 | YU132699 | 35523003A-11 | 294 | 646 | 53 | 62 | 161 | 5.2 | 51 | 115 | 31 | 3 | 802 | 1823 | 2.8 |
| | 16 | 12,836 | 50,946 | | | | | | | | | | | | | | | |

Note: NO MERCURY CONTAMINATION

REMEDY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS

BEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A302E, ASME SA240, QQS788D.

YIH MAU CORP.

16g 304 4 S

100# 186, 184
in Kim Hsing
146

